

Date: Tuesday, 17/02/2009 10:18:13 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR ARM
Job Number :	45811		
Estimate Number :	10505		
P.O. Number :		Part Number :	D2010103
This Issue :	17/02/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2010 REVD
First Issue :	//	Project Number :	N/A
Previous Run :	40667	Drawing Revision :	D
Written By :		Material :	
Checked & Approved By :	JUD 09.02.17	Due Date :	03/03/2009
Comment :	Est : F 02.08.21 Re-format; Added D2057 KJ/RF Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC Est Rev:H 08-06-20 rev.D as per dwg DD verified by:EC		

Qty: 7 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0500W049	304 RD Tube .500 x .049W
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Comment: Qty.: 1.5750 f(s)/Unit Total : 9.4500 f(s)
 Material: 304/316 SS tubing 0.500" Dia. x 0.049" wall
 (M304TR0500W049) Batch No: ~~10108324~~ x3

SP 09/04/07

M 108 823

(7)

2.0	BRAKE NC	NC BRAKE
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Comment: BRAKE NC
 Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727
 Identify as D2010-103

SP 09/04/07

(7)

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 1- Bend as per Dwg D2010 using bending Jig D2010-103T2
 2- Deburr ends

M. 09/04/10

(7X)

4.0	D2057	Plug
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)
 Plug
 Pick:

Qty	Part Number	Description	Batch
1	D2057	Plug	

B 40048 M. 09/04/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:18:13 AM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 45811

Part Number: D2010103

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



(7x)

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-flare before installing plug as per dwg D2010

2-Install D2057 plug as per Dwg D2010

M. 09/04/13

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/13 (x2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M 105642

START TIME:

11:50

OVEN TEMPERATURE:

350°

FINISH TIME:

12:00

BL 09-04-14

(7).

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 09/04/14

(7)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 220

SS 09/04/14 (x2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/14

Job Completion



MF 09-04-14

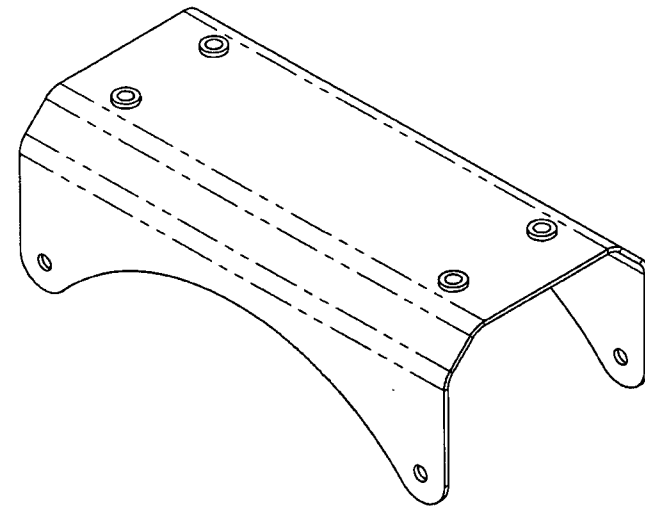
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

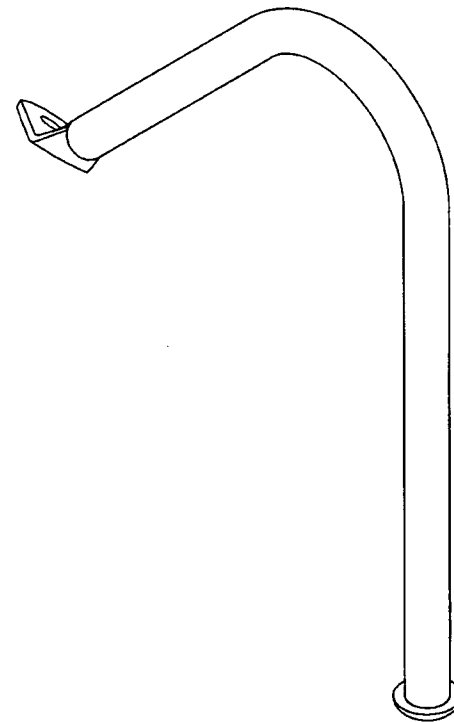
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

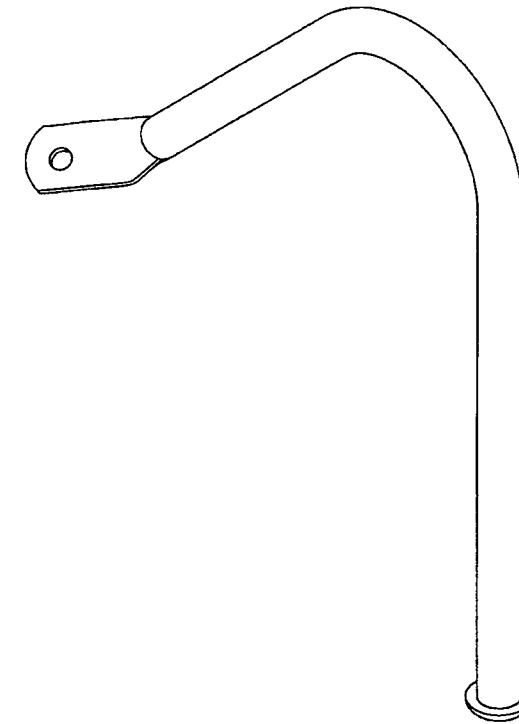
NOTE: Date & initial all entries



D2010-101 MIRROR BRACKET



D2010-103 ARM



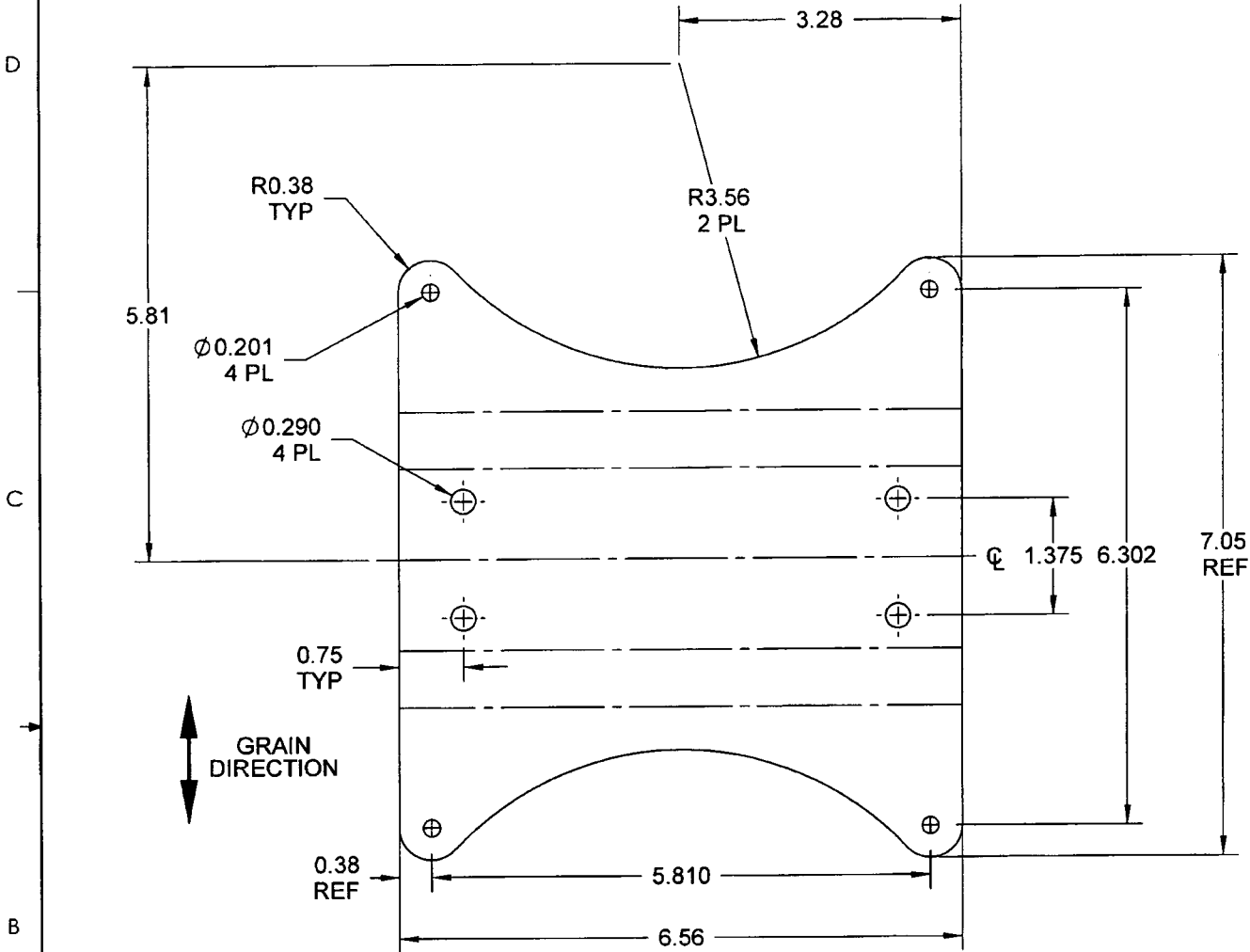
D2010-104 ARM

RELEASED
08.06.10

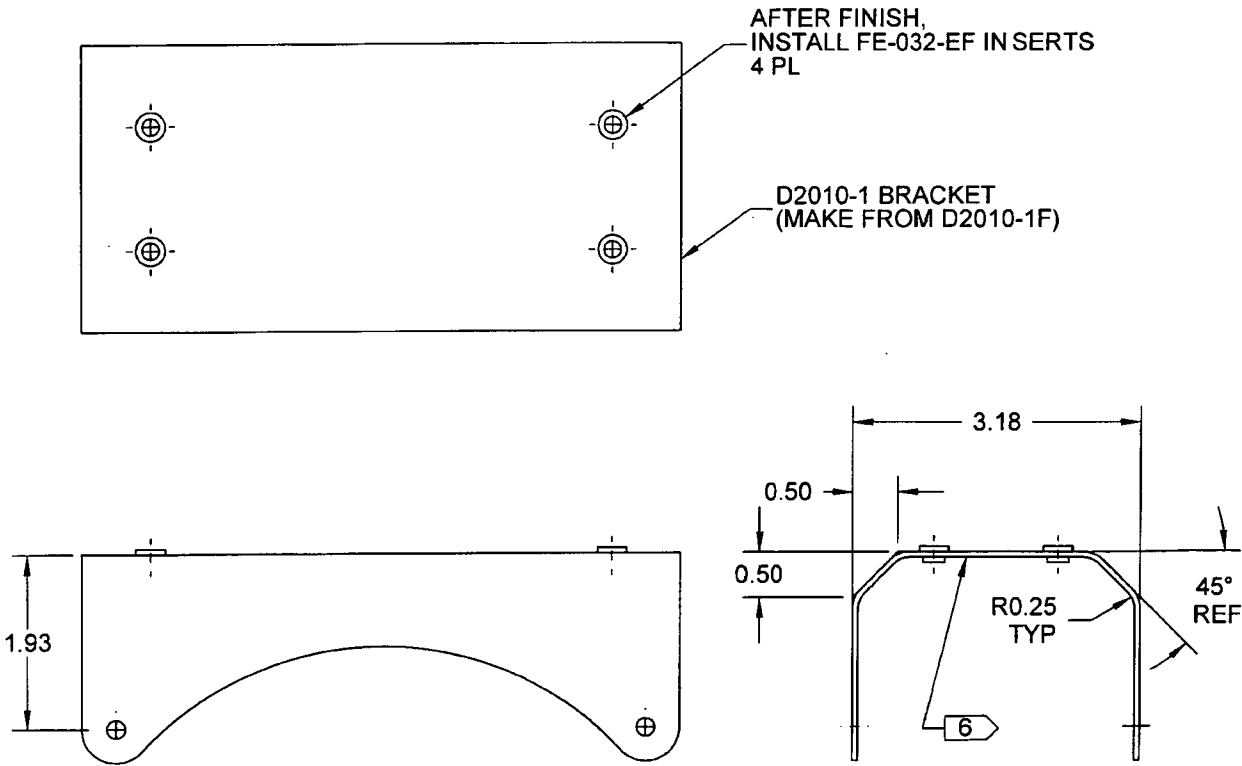
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NO. HS811

D	REDRAWN IN SOLIDWORKS; ADD D2010-1F FLAT PATTERN FOR D2010-101 (ZN B7-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN B1-3, B1-4); REASON; TUBING CRACKING DURING SERVICE	PH	08.06.10
C	1.93 WAS 2.00; 0.50 WAS 0.62	KE	97.10.31
B	7.90 WAS 10.90	JB	92.03.17
A	NEW ISSUE	JB	90.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	JB	DRAWING NO.	REV. D
MFG. APPR.	JB	D2010	SHEET 1 OF 4
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	MIRROR BRACKET	NTS
DATE	08.06.10	COPYRIGHT © 1990 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

QTY -101	P/N	DESCRIPTION
X	D2010-101	MIRROR BRACKET
1	D2010-1	BRACKET
4	FE-032-EF	INSERT



D2010-1F FLAT PATTERN 



D2010-101 MIRROR BRACKET

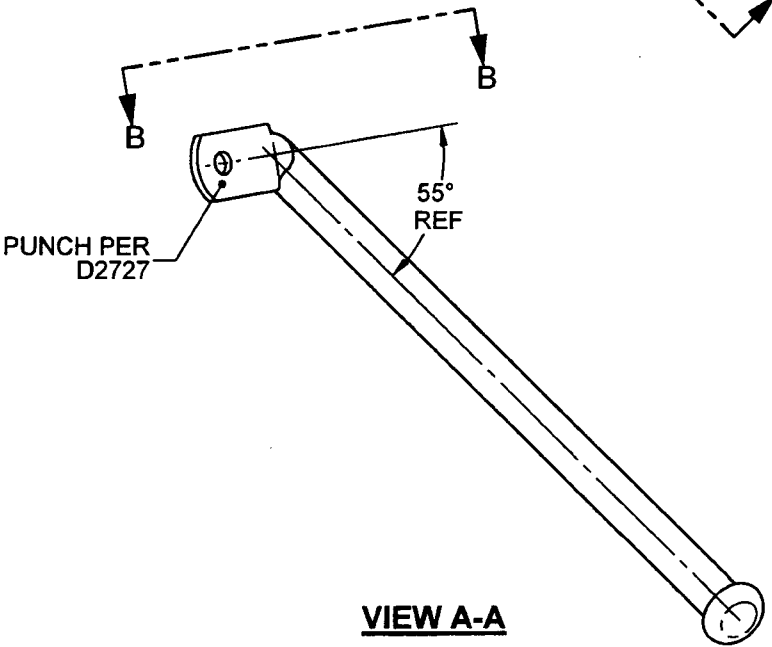
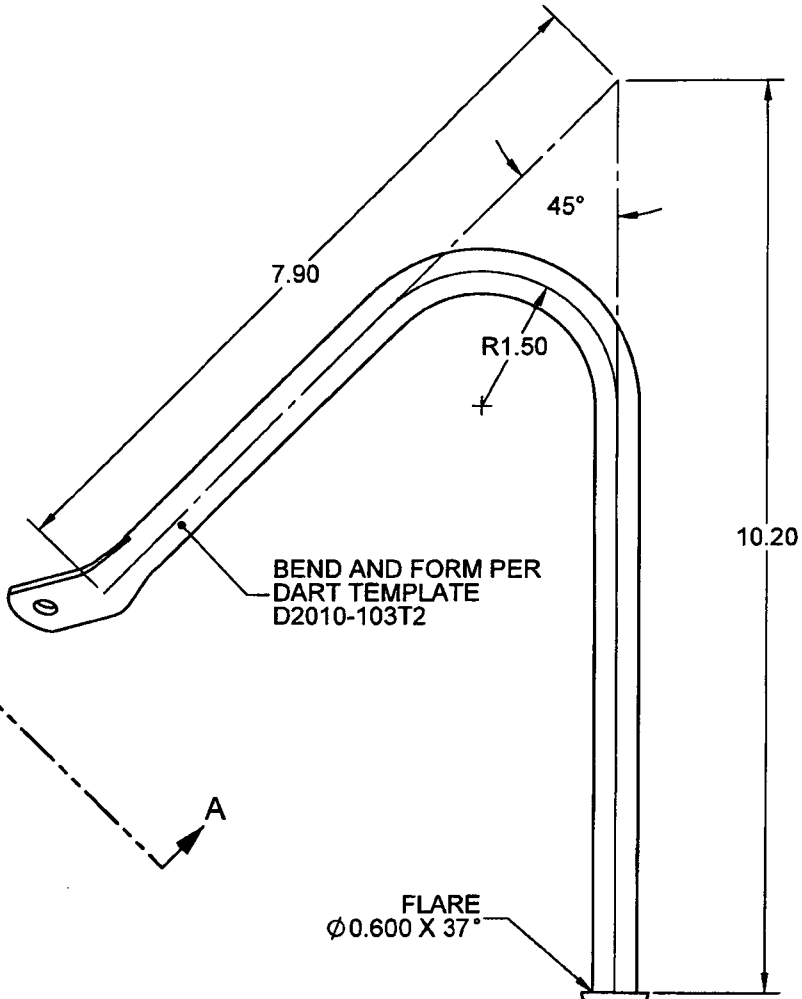
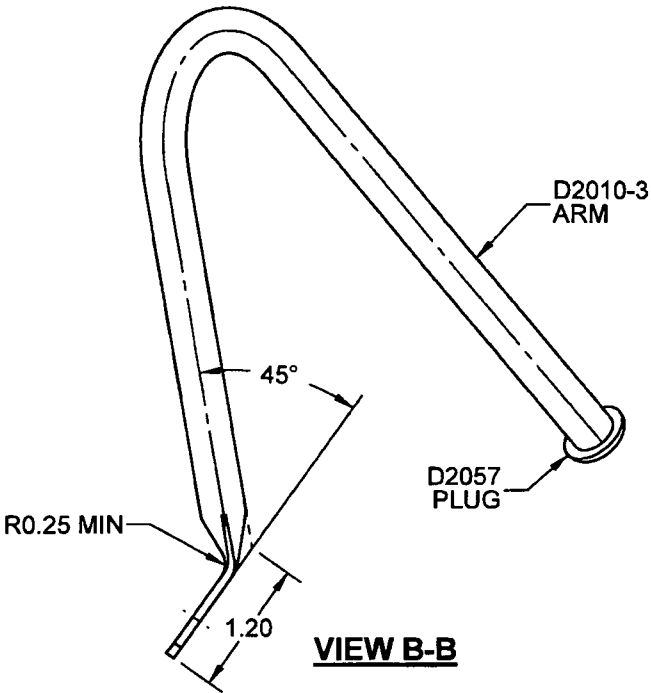
- NOTES:**
- 1) MATERIAL: D2010-1F: 2024-T3 ALUMINUM SHEET, 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-101" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
 - 7) WEIGHT: 0.23 lbs

DESIGN	JB	DART AEROSPACE LTD
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CHECKED	AP	DRAWING NO. REV. D
MFG. APPR.	AP	D2010 SHEET 2 OF 4
APPROVED	AP	TITLE SCALE
DE APPR.	AP	MIRROR BRACKET NTS
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WORK ORDER
NO. 45811

RELEASED
08-06-19/11

QTY -103	P/N	DESCRIPTION
X	D2010-103	ARM
1	D2010-3	ARM
1	D2057	PLUG



RELEASED
08-06-10

- NOTES:**
- 1) MATERIAL: D2010-3: AISI 304/316 SS SEAMLESS ROUND TUBING; $\Phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-103" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

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MFG. APPR.		D2010	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		MIRROR BRACKET	NTS
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QTY -104	P/N	DESCRIPTION
X	D2010-104	ARM
1	D2010-4	ARM
1	D2057	PLUG

RELEASED
08-06-19 11

- NOTES:**
- 1) MATERIAL: D2010-4: AISI 304/316 SS SEAMLESS ROUND TUBING
Ø0.500 X 0.049 WALL
(REF DART SPEC M304TR0.500W.049) Δ
 - 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2010-104" USING WHITE FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.34 lbs

DESIGN	JB	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D2010
MFG. APPR.		REV. D
APPROVED		SHEET 4 OF 4
DE APPR.		TITLE MIRROR BRACKET
DATE	08.06.10	SCALE NTS

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